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## SPECIALTY POLYMER COATINGS, INC. (SPC)

### BRUSH GRADE APPLICATION SPECIFICATION – ACCELERATED CURE FOR COATING OF GIRTH WELDS WITH SPC PIPELINE COATINGS

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#### I. GENERAL

- 1.1 This specification outlines the procedures and methods for preheating the pipe surface of girth welds and applying brush grade kits to facilitate rapid curing of Specialty Polymer Coatings, Inc.'s pipeline coatings.
- 1.2 This specification is utilized when coating girth welds in cold ambient temperature environments or when an accelerated coating cure is required to enable the pipeline to be quickly backfilled and put into service.
- 1.3 This specification is applicable to the following SPC coating systems:
  - SP-2888<sup>®</sup> R.G.
  - SP-3888<sup>®</sup>
  - SP-6888<sup>®</sup>
  - SP-8888<sup>®</sup>
- 1.4 Refer to Specialty Polymer Coatings, Inc.'s Brush Grade Application Specification for the specific coating system in use, and follow the requirements of the specification. Care must be taken to ensure that only Base and Hardener with the same colour coded dots (shown on the container lids) are mixed together. The kit sizes are also identified on the container lids. Only mix Base and Hardener identified by the same kit size. ***Refer to the Colour Chart at the end of this application specification.***

## **BRUSH GRADE APPLICATION SPECIFICATION – ACCELERATED CURE**

### **II. PROCEDURES**

- 2.1 If ice, snow or moisture is present, preheat the weld area with a propane torch to a temperature between 25°C and 35°C (77°F and 95°F). Ensure heat is applied uniformly around the circumference of the pipe, that all snow and ice have been removed, and that the pipe surface to be coated is 3°C (5°F) above the dew point.
  - 2.2 Abrasive blast the weld area to a near-white condition and the required surface profile and cleanliness.
  - 2.3 Using an induction coil or catalytic indirect propane heater (“Ciscan”), preheat the weld area to a temperature between 110°C and 115°C (230°F and 240°F). Ensure heat is applied uniformly around the circumference of the pipe. 3LPE and HPCC coatings should not exceed a preheat temperature of 90°C (194°F).
  - 2.4 Allow the weld area to cool between 80°C and 95°C (175°F and 205°F).
  - 2.4 Using multiple light layers, apply the SPC pipeline coating brush grade kit to the weld area to the required coating thickness. It is recommended that two coaters be used to roll/brush the coating, one on each side of the pipe.
  - 2.5 Allow the applied coating to cure to a hard condition. Approximately 30 minutes.
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**BRUSH GRADE APPLICATION SPECIFICATION – ACCELERATED CURE**

<b>SPECIALTY POLYMER COATINGS, INC. (SPC)</b> <b>BRUSH GRADE COATING KITS</b> <b><u>COLOUR CHART</u></b> <b>Match Base &amp; Hardener Based on Colour Coded Dots Below</b>			
<b><u>SIZE</u></b>	<b><u>COLOUR</u></b>	<b><u>VOLUME</u></b>	
		<b><u>BASE</u></b>	<b><u>HARDENER</u></b>
0.50 Litres	PINK 	0.3750 Litres	0.1250 Litres
0.75 Litres	FL GREEN 	0.5625 Litres	0.1875 Litres
0.90 Litres	FL YELLOW 	0.6750 Litres	0.2250 Litres
1.00 Litres	RED 	0.7500 Litres	0.2500 Litres
1.25 Litres	PURPLE 	0.9375 Litres	0.3125 Litres
1.50 Litres	YELLOW 	1.1250 Litres	0.3750 Litres
1.75 Litres	ORANGE 	1.3125 Litres	0.4375 Litres
2.00 Litres	BLACK 	1.5000 Litres	0.5000 Litres
2.25 Litres	BLUE 	1.6875 Litres	0.5625 Litres
2.50 Litres	GREEN 	1.8750 Litres	0.6250 Litres
2.75 Litres	WHITE 	2.0600 Litres	0.6900 Litres
Note: FL = Fluorescent			